

**Work Order ID 68360**

Tuesday, April 12, 2011 10:11:47 AM



Page 1

Item ID: D4079-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp Half, Attachment

Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: APDate: 11/04/12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4079

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut blank 2.750" long

0.00

SL 11/04/19



110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA931

Folio rev: AADwg Rev: B

0.00

SL 11/04/28



Deburr

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 11/4/28

QC

Memo

0.00

12

0

Quality Control

130

QC8- Inspect parts - second check

0.00

am 11/04/28

QC

Memo

0.00

12

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

12

BL 11-4-28.

Hand Finishing

W/O:		WORK ORDER CHANGES						
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Required Date: 4/15/2011 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Start Time: 1:40  
Over Temp: 320 °F  
Finish Time: 2:10

(12x) ~~12~~ m-1 11/05/06

Powdercoat

Memo

Powder Coating

160

QC3- Inspect Part Finish

0.00

QC

Memo

Quality Control

0.00

11/05/06 (12x)

170

Identify as per dwg &amp; Stock Location: B4

0.00

Packaging

Memo

Packaging

0.00

11/5/06 (12x)

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

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Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11

MUF  
11-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, April 12, 2011 10:11:53 AM

Page 1

Work Order ID: 68360

Parent Item: D4079-1

Parent Item Name: Clamp Half, Attachment

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 10\*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	31.0000	0.23	2.905263			



6061-T6 Bar 2.00 x 2.00



21/04/11

Location

Loc Qty

Loc Code

MAT009

31

113006

11

113123

11

13085

9

2.91

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries



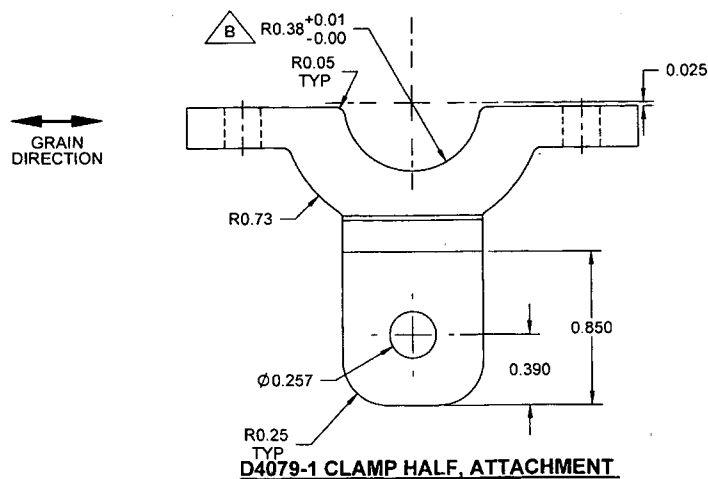
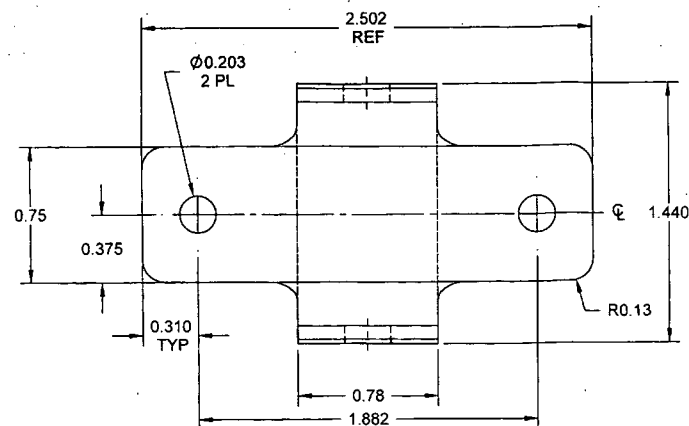
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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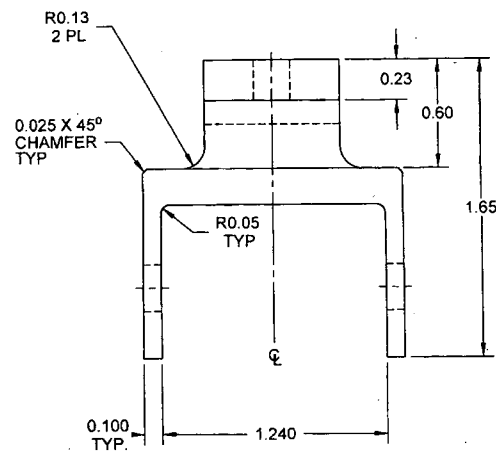
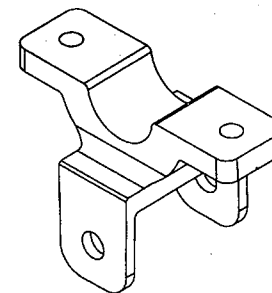
NOTE: Date & initial all entries



**D4079-1 CLAMP HALF, ATTACHMENT**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48360

*11-04-12*



**RELEASED**  
2010-09-07  
*MP*

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

B	R0.38 WAS R0.48	KB	10.07.30
A	NEW ISSUE	KB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN		KB	
DRAWN		KB	
CHECKED		KB	
MFG. APPR.		KB	
APPROVED		KB	
DE APPR.		KB	
DATE	10.07.30		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4079</b>	REV. B SHEET 1 OF 1
TITLE <b>CLAMP HALF, ATTACHMENT</b>	SCALE NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries